

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027596**Date Inspected:** 12-May-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** As noted below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS Components**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QAI) David Gray was at the American Bridge Fluor (ABF) job site between times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

The QAI observed ABF welder Wai Kitlai Welder ID# 2953 welding intermediate and cover passes utilizing the Submerged Arc Welding (SAW) process with F7A6-EM12K-H8 (1/8") diameter electrode Flux 10.62 in the (1G) flat position on the (top side) of the Deck Plate Drop-in Section Longitudinal Field Weld Splice along 13W-PP122. 2. The QAI observed Quality Control Inspector (QCI) Tony Sherwood verify that the minimum preheat temperature was in accordance with Welding Procedure Specification (WPS) 4042B-1 Revision 1; and afterwards verified that the welding parameters (Amps, Volts and Travel Speed) were in accordance with the WPS. This welding was in progress for the duration of the shift. The QAI made subsequent observations throughout the shift to monitor quality and noted that the work appears to be in general accordance with the project plans and specifications.

The QAI observed the following ABF welders noted below performing 1G (flat position) Shielded Metal Arc Welding (SMAW) on the Seismic Performance Critical Member (SPCM) Complete Joint Penetration (CJP) splice butt joint using 3.2mm E7018-H4R electrodes with an average of 130amps. This welding was in progress for the duration of the shift.

The welding consists of root and intermediate weld passes. At the 13W-A2.1 and 13W W2.2 locationS Salvador Sandoval ID# 2202, 13W-W2.1 Steven Davis ID# 7889, 13W-W2.3 Jacob Stafford ID# 8020, 13W-W2.5 Mike Jimenez,13W-PP123.6 and W13-W2.2 Khit Lounezhaney ID# 4985 and 13W-PP122.3 and W14-W2.4 Edward

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Brown ID# 9331. QCI Inspectors William Sherwood and Salvador Merino were observed monitoring the welding parameters for compliance to ABF-WPS-D1.5-1040C-CU Revision 0 and measuring inter-pass temperatures between passes. During subsequent observations it was noted that the welders were using a power disc grinder at weld starts and stops as needed and were cleaning between weld passes with power wire wheel brushes.

Summary of Conversations:

Except as noted above no significant conversations were held on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Gray,David	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
